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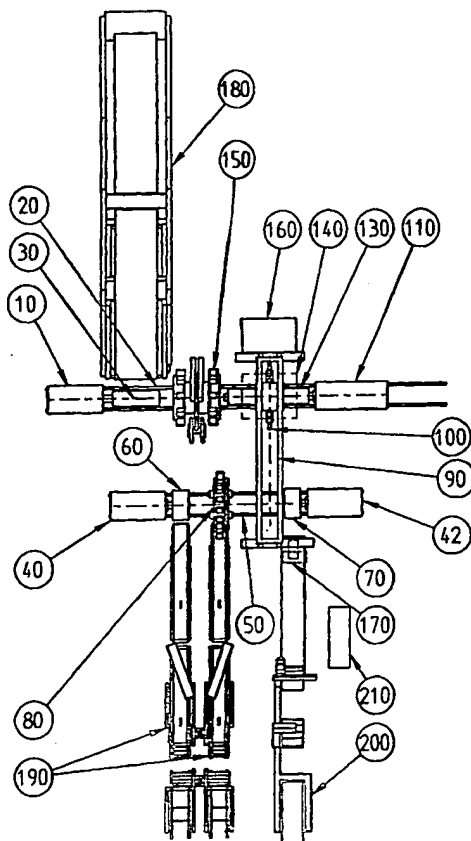
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(54) Title: METHOD AND PLANT FOR THE MANUFACTURE OF GREEN TYRES



(57) Abstract: The assembly of devices for production of green tyres, consisting of a belt building drum, tread building drum, band drum for preparing a carcass and a forming drum and further includes devices for transferring particular components or assemblies of the components from one device to another, an apparatus for placing and holding a bead and the carcass assembly, stitching unit, and particular servisers for supplying materials to particular devices. The assembly of devices is arranged into two parallel transfer tracks 20 and 50 and includes the band drum 30 for preparing carcass assembly, the tyre building drum 130, the apparatus 150 for placing and holding the head and the carcass assembly on the first transfer track 20, the apparatus 150 is disposed between the said band drum 30 for preparing the carcass assembly, and the tyre-building drum 130. On the second transfer track 50 there are belt drum 60, band drum 70 for winding a tread around the belt and a first transfer ring 80 between the said belt drum 60 and band drum 70 for winding a tread all being movably disposed. There is an auxiliary track 90 arranged in a horizontal plane above the place 140 of assembly, the auxiliary track runs at right angles in relation to the first and second transfers tracks (20, 50). Under the auxiliary track 90 there is a second transfer ring for transferring a belt-tread assembly on the place 140 of assembly movably hand on the said track 90.

WO 03/084737 A1